	Work Order ID 81397 March-14-12 7:47:18 AM		*81397*						Paş			
Revision ID:	D350-636-015 Skidtube STD w/ Training Wearplates	s, LH	Accept	*N900	040	100)*	Setup Sta	1	NS1* NS2*		
Start Date: Required Date:	13/03/2012 Start Qty: 1.00 27/03/2012 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:				•			
Reference: Approvals:	Process Plan: MLJ QC:	Date: \2 03 \	\\Tooling: SPC (Y/N):		ate:				art * op *	NR1* NR2*		
Sequence ID/ Work Center ID Draw Nbr	Operation Description Revision Nbr		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept	t Reject Qty	Reject Numb	-		
D3492	C											
D4168	A											
IIN-D350-636	I											
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Photocopy blue file and type labels per PPP D350-636-015 CHG 002 Start 0 5

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March-14-12 7:				 -	*81:3	19/*							Page 2
Revision ID:	D350-636-01		Wearplates, LH		Accept	*N900	ገበ4ሰ	1100)*	Setup	Start Stop	*N:	S1* S2*
Start Date: Required Date: Reference:	13/03/2012 27/03/2012	Start Qty Req'd Qt		*1* *1*		Cust Item Customer							<i>y</i> *
Approvals:	Process Pla	n:		ate:			Date:	····		Run	Start Stòp	*N *N	R1* R2*
Sequence ID/ Work Center ID 110 *110* Skidtubes Skidtubes			Memo 1- Pick D2600-3 E 2- Deburr FWD ar AFT end per dwg 3- Drill pilot holes deburr, section H- 4- Locate DT8330 fitting, section H-I	nd AFT ends, remo D4168 for blade fitting bo H off of blade fitting H	Set Up/ Run Hours 0.00 0.00 ve bending marks. Scribe bending bolt holes using DT8983. Open bolt holes and drill pilot heads. Ensure proper positioning	en to 0.500",	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
***			Jig DT8150 & DT 7- Clecko DT8863 ***SECOND SID 8- Drill most FWI 9-Open up holes o	as per Dwg D4168 8863A for first side BB on second side of E*** D wearplate hole us f Detail A to 0.297	3 sheet 4 (D4168-1 details). e only DT8863B for second of tube and drill pilot holes sing DT9678 locating off of " (total of 2 holes per side) il D section H-H to 0.500" a	side (detail B) For detail B. 66.54" hole. and .201" (total			\mathcal{F}	12/2	3)22	2	·

10-Weld D2744 Cap as per Dwg D4168 and QSI 004.Fill grooves in bend left from bending as per QSI 004

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Work Order ID 81397 March-14-12 7:47:18 AM				*81397*						
Item ID: Revision ID:	D350-636-01	15		Accept	*N900	040100)* Se	etup Start	INTO	_
Item Name:	Skidtube STD	w/ Training Wearplate:	s, LH					Stop	*NS2*	
Start Date: Required Date:	13/03/2012 27/03/2012	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item II Customer:) :				
Reference: Approvals:		n:			Da Da	te:	R	un Start Stop	"NR I"	
Sequence ID/ Work Center II)		inum Rod batch: //) elds flush as per Dwg D416	_	Tool ID BE 2/03/ CF 1.	Tool # Plan Code 22 2 · 3 · 22	Accept Qty		Reject Insp. Number Stamp	
120 *120* QC Quality Control		QC10- Inspect visual per	r QS1004- ground welds	0.00	1 12·03·	22	- 1 <u>×</u> -	- J		
130 *13 0 *		QC5- Inspect part compl	eteness to step on W/O	0.00	1,3/27					
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Quality Control

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Item ID: Revision ID: Item Name:	D350-636-0 Skidtube STD	15 D w/ Training Wearplate	s, LH	Accept	*N900	040	100)*	Setup S	Start Stop	1 4	S1*	17.77
Start Date: Required Date: Reference:	13/03/2012 : 27/03/2012	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item 1 Customer:	ID:							
Approvals:	Process Pla	an:	Date:	Tooling:	D	 ate:			Run S	Start	*N	R1*	
			Date:	SPC (Y/N):	D	ate:			S	Stop	*N!	R2*	
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept	Reject Qty		Reject Tumber	Insp. Stamp	
*140 *140* HandFinish Hand Finishing		Chemical Conversion Co	oat per QSI005 4.1	0.00				74	4	23	3-27	·	
150		QC3- Inspect Part Finish		0.00									

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Part No:		PAR #:	Fault Category:		NCR: Ye	s No I	DQA:	Date: _	····
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DATE	STEP	Section A	Initial	Action Description	Sig	n& s			
DATE	STEP	Section A	Initial	Action Description	Sig	n& s			Approval QC Inspector

9- At section AJ-AJ drill out x-bolt spacer to 0.404"

A/R Aluminum Rod batch: M120/6

(welding instructions on sheet 8)

& QSI004

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NCR:			WORK ORD	ER NON-CO	NFORMANC	E (NCR)			
	/-	Description of NC		Corrective Act	ion Section B		Verification	Approvai	Approval
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Item ID: Revision ID: Item Name:	D350-636-01	15 w/ Training Wearplate	s I H	Accept	*N900	040100 3	k Setup Star Stop	1/1/2 1
Start Date: Required Date: Reference:	13/03/2012	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:		IN 57
Approvals:	Process Pla	n:	Date:	Tooling: SPC (Y/N):		ate:	Run Star Stop	"NR1"
Sequence ID/ Work Center II)	11-Spot fac dwg D4168	, section AL-AL section CG-CG	Set Up/ Run Hours 4168 section (total of 4 places pe	Tool ID		Accept Reject Oty Qty -12-03-30 03-49	Reject Insp. Number Stamp
		******* HOLE IN 1		W O UBE IF APPLICABLE DRI	LL TOW RING			

170

QC10- Inspect visual per QSI004- ground welds

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Work Orde		397		\ *813	897*				Page 7
Item ID: Revision ID: Item Name:	D350-636-0	15 w/ Training Wearplates		Accept	*N9000401	100*	Setup	Start Stop	*NS1* *NS2*
Start Date: Required Date: Reference:	13/03/2012	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item ID: Customer:			-	IN. O.
Approvals:	Process Pla	in:	Date:	Tooling: SPC (Y/N):	Date:		Run	Start Stop	*NR1* *NR2*
Sequence ID/ Work Center II 180 *180* QC Quality Control	D .	Operation Description QC5- Inspect part comple Memo	eteness to step on W/O	Set Up/ Run Hours 0.00 0.00	man in the contract of the con	Plan Acce Code Qty	pt Reje Qty		Reject Insp. Number Stamp
100 HandFinish Hand Finishing		Pressure Wash per QSI00 Memo Re-alodine to	ube as per QSI 005 section	0.00 0.00 4.1.2.1 do not acid etch.		1χ,	DM	1-1	12/04/6
200 **200* Powdercoat Powder Coating		OVEN TEM	per QS1005 4.3-Alum E: 2 3 0 PERATURE: 320° F E: 3 500	0.00			_ &		P) 12/04/04

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Part No		PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	_ Date: _	
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Work Ord <i>March-14-12 7</i>		397		*813	397*				Page 8
Item ID: Revision ID: Item Name:	D350-636-0 Skidtube STD	15 w/ Training Wearplates	, LH	Accept	*N900040	100*	Setup St	1.	IS1* IS2*
Start Date: Required Date: Reference:	13/03/2012 : 27/03/2012	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item ID: Customer:			•	
Approvals:		in:	Date:		Date:			top *N	IR1* IR2*
Sequence ID/ Work Center I 210 *21 \rightarrow* QC Quality Control	D	Operation Description QC3- Inspect Part Finish Memo Inspect for fo	oreign object per QSI 024	Set Up/ Run Hours 0.00	Tool ID Tool #	Plan Acce Code Qty	Reject Qty	Reject Number	Insp. r Stamp
220 *20 HandFinish		HandFinishing Mem o		0.00		128	M	1 16	1/04/00

1- Install inserts as per Dwg D4168

Hand Finishing

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Work Ord March-14-12 7		397		*813	397*				Page 9
Item ID: Revision ID: Item Name:	D350-636-0	15 w/ Training Wearplates	, LH	Accept	*N900040	1100*	Setup	Start Stop	*NS1* *NS2*
Start Date: Required Date: Reference:	13/03/2012 27/03/2012	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item ID: Customer:				14(1)
Approvals:		n:			Date:		Run	Start Stop	*NR1* *NR2*
Sequence ID/ Work Center II 230 *730* HandFinish Hand Finishing	D	2-Spray insid 3-Install blac per dwg D41 SIKA FLEX BATCH: EXP DATE: 4-assemble o A/R 55-o'rin	68 241 M Co Tring to plue as per dwg I g lube batch:	D3492 and apply o'ring lub	ng hardware as	Plan Acce Code Qty	ept Re Qt	•	Reject Insp. Number Stamp
*240 *240* QC		QC5- Inspect part comple	teness to step on W/O	0.00	loules				

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Item ID: Revision ID: Item Name:	D350-636-0	15 W/ Training Wearplate:	. 111	Accept	*N900	040	110	n *	Setup Star Sto	14.21
Start Date: Required Date: Reference:	13/03/2012	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item Customer:	ID:				NS7
Approvals:	Process Pla		Date:	Tooling: SPC (Y/N):		ate:		1	Run Star Stoj	"NR1"
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Insp. Number Stamp
250		Pick Kit		0.00			Couc	Q CJ	V .3	rumber Stamp
250 Packaging		Memo		0.00					80	12-04-0
Packaging			4A 2A	18 7 7 7				.*		
260		QC4- 100% Inspect kits	for completeness	0.00						
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******ensure antiseize is on AN8C21A bolts******

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Packaging

Packaging

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Packaging

Identify and pack for shipping as per PPPD350-636-015
Location:
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Item ID: Revision ID: Item Name:	D350-636-01 Skidtube STD	15 w/ Training Wearplates	, LH	Accept	*N900	040	100) *	Setup	Start Stop		S1* S2*
Start Date: Required Date: Reference:	13/03/2012 27/03/2012	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:						
Approvals:	0.0	in:	Date:			ate:		I	Run	Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center II 280 *280* QC Quality Control	D	Operation Description QC21- Final Inspection -	Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp

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Work Order ID: 813	397		*(14207	*							
				31397								
	50-636-015		*[ገ350-	636-0	15*						
Parent Item Name:	Skidtube STD w/ T	raining Wearplat	es, LH						art Date: 13/		•	l Date: 27/03/2012
								S	Start Qty: 1.0	0	Require	d Qty: 1.00
Comments:	IPP rev:A 10.09.2 11.04.14 ecn11-55 NCR 11-906 DD v	3 DD verf:EC	verf:EC		IPP Ro Rev:C 11.10.1							
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Status Issued
AN3C34A		Purchased	No		·· - ·	230	Each	51.0000	1	1	,	
AN3C34	Α								**	m-L	12/	04/05
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AN3C36A	(Purchased	No		117011	230	Each	158.0000	4	4	_	
AN3C36	Δ\/								**	/	' 1	11-
*AN3C36	7 *									MIN	12/	14/05 c
				Location	l	Loc	<u>Qty</u>	Loc Code		,-	•	<i>V</i> -
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· Picklist Print March-14-12 7:47:23 AM									Page 2
Work Order ID: 81397 Parent Item: D350-636-015 Parent Item Name: Skidtube STD	w/ Training Wearplates,	*D	1397* 350-636-0	15*		St	art Date:	13/03/2012	Required Date: 27/03/2012
						S	tart Qty:	1.00	Required Qty: 1.00
AN3C37A	Purchased	No		230	Each	110.0000	l ★★	1	
AN3C37A							~ ~	80	12-04-09 81
>			Location	<u>Lo</u>	e Qty	Loc Code			
			ST354 116874		110 11				_
			117010 120422		2 47				
			120731		50				- -
AN3C42A	Purchased	No		230	Each	43.0000	**	1	
AN3C42A							^ ^	-80-	12-04-09 6
			Location	<u>Lo</u>	c Qty	Loc Code			
			ST354 106176		43				
			118131		2				_
			119673		15			/V	
D2402 I	3 6 4 1	N.	120464	220	25 Fach	130.0000	8		_
*D3492-1	Manufactured	No		230 .	Each	130.0000	**	8	12/04/05
Plug								MAR	12/04/05
			<u>Location</u>	Lo	c Qty	Loc Code			
			FP002 69531		130 8				_
			74444		2				
			76235		20				-
			77037		100		÷	8	_

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DATE	STEP	Description of NC	1 242 - 4	Corrective Action Section		Verific		Approval	Approval
	0	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		on C	Chief Eng	QC Inspector
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Work Order ID: 81397	<u></u>	*81	397*					· · ·		74
Parent Item: D350-63	6-015		 350-636-0	715*						
	tube STD w/ Training Wearplates,	LH	1:11/-11.717-1	113			art Date: tart Qty:	3/03/2012	Required Date: 27/03 Required Qty: 1.00	/2012
D3492-3	Manufactured	No		230	Each	69.0000	8	8		
D3492-3							**	JU,	200109	1
			Location FP-A 	<u>Loc</u>	Oty 69 69	Loc Code B819	آء	<u> </u>	_	
D3873-1	Manufactured	No	~	230	Each	228.0000	7	7	_	
D3873-1							**	m./	12/04/0	5
			Location	Loc	<u>Oty</u>	Loc Code			' / '	
			ST057		182	— (==				
			79561		182	7670	al	7	_	
			ST067 64760		46	, , ,				
			68247		4					
			73829		19					
			73830		2					
DA154 041		NI-	79560	220	20 Fach	2 0000	1	1	_	
*D4154-041 *D4154-041 Wearplate Assembly	Manufactured ★	No		230	Each	2.0000	**		112/04/0	15
,			Location	Loc	Oty	Loc Code		• •		
			FG 77007		2 2	8076	101	_	_	
D4170-1	Manufactured	No		230	Each	13.0000	4	4	7	/ /
D4170-1							**		<i>Bel</i> B 82043	2/03/29
			Location	Loc	Qty	Loc Code		•	00010	~ 7
			LG001		13				_	
			71844		5				_	
			76677		8				_	

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DATE	STEP	Description of NC			tion B	0:	Verific	ation	Approval	Approval				
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Picklist Pri March-14-12 7:											Page 4
Work Order ID: Parent Item: Parent Item Name	D350-636-015	raining Wearplates,	*D	1397 350-	/* -636-01	15*			art Date: Start Qty:	13/03/2012 1.00	Required Date: 27/03/2012 Required Qty: 1.00
D4171-1 *\(\begin{align*} \begin{align*} ali	-1 *	Manufactured	No	Location ST135	<u>1</u> 77008	230 <u>L</u>	Each 7 9 9	9.0000 561 <u>Loc Code</u>	1 **	1 - M-	L 12/04/05
MS21043-3 *MS210	043-3*	Purchased	No	Location FG GA ST301	103691 120693 118077 118614 118686 119758	230 <u>L</u>	72 72 334 334 434 2 382 30 20	840.0000 <u>Loc Code</u>	**	m./	12/04/05
*NAS1149C0363R *NAS11 Washer	4900363	Purchased R*	No	Location ST297	114742	230 <u>L</u>	Each oc Oty 3381 3381	3,381.000	**	m h	12/04/05

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Work Order ID: 81397 Parent Item: D350-636-015 Parent Item Name: Skidtube STD w/	Training Wearplat	*[1397* 350-636-0)15*			12/02/2012	1
Tarent Hem Name. Skiddoc 31D W	Training wearpiar	cs, LH				Start Dat Start Qt	e: 13/03/2012 y: 1.00	Required Date: 27/03/2012 Required Qty: 1.00
NAS1515H3L	Purchased	No		230	Each	184.0000	4 4	
*NAS1515H3I *						**	mil	12/04/05
			Location	Loc Qty	4	Loc Code	. 2	
			FG		10			
			102472		10			
			ST277	14				
			118686		3			
			119438 120072	Δ	1		H	
			120360	. 10			- t	· · ·
NAS1611-010	Purchased	No		230	Each	209.0000	8 8	
NAS1611-010						**	,	. /
O-RING							m	12/04/05
			Location	Loc Qty	,	Loc Code	110/1/1	10709/00
			FP	<u> 200 Q 1</u>		<u> 200 Code</u>		·
			110915		0 .	^ .		
			120770		0	21166		
			FP001	15	9	,,,,,		
			110915	1	4			
			117460		8			
			118077		1			•
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Part No	:	PAR #:	Fault Cate	egory:	NC	R: Yes	No DQ	A:	_ Date: _	
	R	esolution:	Disposition	on:	QA	: N/C Cld	osed:		Date: _	
NCR:			WORK ORD	ER NON-CONFO	RMANCE	(NCR)			
DATE	STEP	Description of NC		Corrective Action	Section B	Ciam e	Verific		Approval	Approval
	O.L.	Section A	Initial Chief Eng	Action Descrip Chief Eng	nuon	Sign & Date	Secti	on C	Chief Eng	QC Inspector
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Work Order ID: 81397		*81	397*						ıU
Parent Item: D350-636-015 Parent Item Name: Skidtube STD w/	Training Wearplates,	*D:3	350-636-0	15*			art Date: tart Qty:	13/03/2012 1.00	Required Date: 27/03/2012 Required Qty: 1.00
NAS1611-013	Purchased	No		230	Each	168.0000	8	8	
NAS1611-013							**	M12116	o(ve) Mularlax
			Location FP001 116582 117291 117887 119623 120360	<u>Lc</u>	168 5 2 53 36 22	<u>Loc Code</u>			- - - - -
NAS1149D0863J	Purchased	No	120910	250	50 Each	231.0000	2	2	
>*NAS1149D0863 WASHER		140		230	Lacii	231.0000	**	-	12-04-09 6
			Location ST298 118078 - 119307 120308	<u>Lc</u>	231 36 95 100	Loc Code		-2r	- - -
*D2744	Manufactured	No	.20300	110	Each	60.0000	1 **	1	BE12/03/22
Сар			Location LG002 62715 70881 71861 78900	<u>Lo</u>	60 1 10 7 42	Loc Code			, , ,

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Part No		PAR #:	Fault Cated	orv:	NCR:	Yes	No DQ/	\:	Date:		
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DATE	STEP	Description of NC		Corrective Action Secti			Verific	ation	Approval	Approval	
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Work Order ID: 81397 Parent Item: D350-636-015 Parent Item Name: Skidtube STD w/ Training Wearplates, L		*D	1397* 350-636-0 <i>°</i>	Start Date:	13/03/2012	Required Date: 27/03/2012	
					Start Qty:		Required Qty: 1.00
*D2600-3-BENT *D2600-3-BFNT* Extrusion Bent	Manufactured	No		110 Each	25.0000 1 **		B 12/03/22
			LG 66875 73253 75021 75022 75023 81330	Loc Oty 25 7 1 1 1 1 1 1	<u>Loc Code</u>		- - - -
D2743 *D2743* Crossbolt Spacer	Manufactured	No	81330	14 160 Each	248.0000 8 **	8	BE12/03/29
			Location LG001 67766 68251 73403 74445 78603 79517	248 4 3 64 1 76	<u>Loc Code</u>	8	• • • • • • • • • • • • • • • • • • •
D2739 *D2739* 3501Beam	Manufactured	No	Location 6/508 LG 72155 80083	160 Each Loc Oty 8 1 7	8.0000 1 ** Loc Code *	l	76-12-3-38 Ne n/03/23

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Part No:		PAR #:	NR #: Fault Category: N			Yes N	lo DQ	۸:	Date:			
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NCR:	-	V	VORK ORD	ER NON-CONFORM	IANCE	(NCR)						
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Work Order ID: 81397	· · · · · · · · · · · · · · · · · · ·	*81	1397*						14
Parent Item: D350-636-015			350-636-0	15*					((
Parent Item Name: Skidtube STD w/ Ts	raining Wearplates,	LH J.	.5:307-0.565-07	13)			art Date: 1		Required Date: 27/03/2012 Required Qty: 1.00
D3490-3	Manufactured	No		160	Each	38.0000	4	4	,
D3490-3 Cross Bolt Spacer							**		BE 2/03/29
•			Location	<u>Lo</u>	c Oty	Loc Code			B 2016 / x4
			LG001		38				_
			78800		38				-
D3490-1	Manufactured	No		160	Each	49.0000	4	4	
D3490-1 Cross Bolt Spacer							**		B 81976 412/03/29
			Location	<u>Lo</u>	c Qty	Loc Code			01176
			LG001		49				_
			62450		2			· · · · · · · · · · · · · · · · · · ·	-
			74875		4				-
			77042 78793		3 40				-
ALS4-1032-225	Purchased	No	10175	230	Each	1,134.000	4	4	-
	Turchased				240	1,10000	**		1 /
AI S4-1032-225							~~	Mil	12/04/05
			<u>Location</u>	<u>Lo</u>	c Oty	Loc Code		•	V
			ST281		1021				-
			108696 110768		146 62				-
			118386	/	55				_
			118966		68				-
			120671 🗸		690			4	-
			ST282		113				-
			120410		100				-
			120451		13				_

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Part No	:	PAR #:	Fault Categ	ory:	_ NCR: Yes I	No DQA:		_ Date: _	· · · · · ·				
	Res	solution:	Disposition	:	_ QA: N/C Cld	sed:		Date:					
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DATE	STEP	Description of NC			ion B	Verificat	tion	Approval	Approval				
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Parent Item: D350-636-015 *D350-636-015* Parent Item Name: Skidtube STD w/ Training Wearplates, LH **D350-636-015 *D350-636-015* Start Date: 13/03/2012 Required Date: 27/03/2012 Required Oty: 1.00 **AN8C35A Purchased No 230 Each 65.0000 1 1 **AN8C35A* **BOLT Loc Oty Loc Code	Picklist Print March-14-12 7:47:23 AM										Page 9
Start Date: 13/03/2012 Required Date: 27/03/2012 R	Work Order ID: 81397	···································									14
ANRC.35A BOLT Location FP002 64		v/ Training Wearplates	^] , LH	350-	-6:36-0°	15^					
Location Loc Code FP002 64 115960 115960 118324 100 10	AN8C35A	Purchased	No			230	Each	65.0000	1	1	
Location Loc Code FP002 64 115960 117834 10 118245 118245 10 118	*AN8C35A*								**	MI	12/64/06
115960					<u>n</u>	L	oc Qty	Loc Code		•	·
17834				FP002	115060						=
118286					/						_
114442											- -
115188 0				ST346			•				
D3488-041 Manufactured No 230 Each 17,0000 1 1 *D3488-041* Blade Fitting Assembly, LH Location Loc Otv Loc Code FP002 17											-
D3488-041 Blade Fitting Assembly, LH Location Loc Oty Loc Code							1				-
Location Loc Otv Loc Code FP002 17	D3488-041	Manufactured	No			230	Each	17.0000	1	1	,
FP002 17 61689 1 75056 7 77021 9 AN6C44A Purchased No 230 Each 107.0000 4 *AN6C44A* BOLT Location Loc Oty Loc Code FG 2 103964 2 ST343 105 120095 12 120143 25 120465 27 120641 21	*D3488-041* Blade Fitting Assembly, LH								**	mA	12/04/05
AN6C44A Purchased No 230 Each 107.0000 4 *AN6C.44A* BOLT Location Loc Oty Loc Code FG 2 103964 2 ST343 105 120095 12 120143 25 120465 27 120641 21					<u>n</u>	L		Loc Code			·
75056 77021 9 AN6C44A Purchased No 230 Each 107.0000 4 *AN6C.44A* BOLT Location Loc Oty Loc Code				FP002	(1(00)					-	-
AN6C44A Purchased No 230 Each 107.0000 4 4 *AN6C44A* BOLT Location Loc Oty Loc Code FG 2 103964 2 ST343 105 120095 12 120143 25 120465 27 120641 21					,					1	-
AN6C.44A BOLT Location Loc Otv Loc Code FG 2 103964 2 ST343 105 120095 12 120143 120465 120465 120641 21					77021		9				-
Elocation Loc Otv Loc Code FG 2		Purchased	No			230	Each	107.0000		4	
FG 2 103964 2 ST343 105 120095 12 120143 25 120465 27 120641 21	*AN6C44A*								**	mil	,12/04/05
103964 2 ST343 105 120095 12 120143 25 120465 27 120641 21					<u>n</u>	<u>Lo</u>		Loc Code			•
ST343 105 120095 12 120143 25 120465 27 120641 21				FG	102064						- \/ _
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120465 27 120641 21				0.0.0	120095						_ · · /
120641 21					,					-11	_
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		Section A	Chief Eng	Action Description Chief Eng	Date		on C	Chief Eng	QC Inspector				
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March-14-12 7:									Page 10
Work Order ID:	81397	·	*81	397*					14
Parent Item: Parent Item Name	D350-636-015 :: Skidtube STD w/ T	raining Wearplates,	*D3	50-636-01	5*		art Date:	13/03/2012 1.00	Required Date: 27/03/2012 Required Qty: 1.00
MS21083C8		Purchased	No		230 Each	85.0000	1	1	
MS210	183C8						**	MA	12/04/05
				Location .	Loc Qty	Loc Code			- • • [
				FP002 115884	1				
				ST303	14				
				115884	0				
				118077	1				
				119309	2	•			
				119436 119638	9				
			,	ST304	70				
				120142	20			1	
				120731	25				
				121011	25				
D3631-1		Manufactured	No		230 Each	223.0000	8	8 .	
D3631	-1						**	mf	12/04/05
			1	Location	Loc Oty	Loc Code		•	• •
			\$	ST072	223				
				68062	2				
1210700101	371011100000			75548 🗸	221			\$	\
AN960C10L	NAS1149C0332 R	Purchased	No		230 Each	0.0000	4	4	*
*AN960 washer	C10I *						**		12/04/05
				W	121255			4	

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Part No		PAR #:	_ Fault Cat	egory:	_ NCR: Yes	No DQ	A:	Date: _	
	R	esolution:	_ Dispositi	on:	_ QA: N/C CI	osed:		Date: _	
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DATE	STEP	Description of NC		Corrective Action Secti		Verific	cation	Approval	Approval
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Work Order ID: 81397		*8	1397*			··· —- ·· — ··		16
Parent Item: D350-636 Parent Item Name: Skidtu	5-015 ube STD w/ Training Wearplates,	*[)350-636-0°	15*		Start Date: Start Qty:	13/03/2012 1.00	Required Date: 27/03/2012 Required Qty: 1.00
D2745	Manufactured	No		230	Each	136.0000 8	8	
D2745 Bushing						**	my	12/04/05
			<u>Location</u>	<u>L</u> c	c Qty	Loc Code	,	. 10
			FP 79518		100 100		7	-
			FP001		36			-
			69529		1		-	-
			76142		1			_
NAC114000002D			78597		34			<u>-</u>
NAS1149C0832R	Purchased	No		230	Each	304.0000	1	,
NAS1149C	0832R					**	MA	12/04/05
			<u>Location</u>	Lo	c Oty	Loc Code	,	•
			ST297		304			_
			114015		204			

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Part No	•	PAR #:	Fault Cate	egory:	NCR:	Yes I	No DQ	A:	Date:	····				
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Work Order ID: 81397		*8	1397*				
Parent Item: D350-636-015			350-636-0	115*			
Parent Item Name: Skidtube STD	w/ Training Wearplate	es, LH	,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,	, , ,		art Date: 13/03/2012 tart Qty: 1.00	Required Date: 27/03/2012 Required Qty: 1.00
AN3C6A	Purchased	No		230 E	ach 623.0000	4 4	
AN3C6A						** M/	1 12/04/05
			Location	Loc Oty	Loc Code	,	
			FP001	1			
			111982	1			
			ST351	622			
			111982	2			
			116419	23			
			116549	2			
			116704 117619	12			
			117688	10		•	
			117872	5		. 1 7	•
			118422	/ 13			
			119449	21			
			120423	133		7	
			120693	400			
MS21043-6	Purchased	No		230 E	ach 809.0000	4 4	,
MS21043-6						** -M-1	12/04/05
			Location	Loc Qty	Loc Code	/	•
			FG	20			
			103693	20			
	•		ST301	789			
			112314	83		Ц	
			117887	6		(<u> </u>
			118384	200		47.41	<u> </u>
			120308	500			

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Work Order ID: 81397		*8	1397*						11
Parent Item: D350-636-015			350-636-0	15*					()
Parent Item Name: Skidtube STD v	v/ Training Wearplates,	LH '		, , ,		St	tart Date: 1	3/03/2012	Required Date: 27/03/2012
						S	Start Qty: 1	.00	Required Qty: 1.00
D3493-1	Manufactured	No		250	Each	66.0000	2	2	1
D3493-1 Washer							**	8	
			Location	Lo	e Qty	Loc Code			
			ST050		66				-
			70697		2			\neg	-
			77573 78835		24 40			$- \Rightarrow x$	-
MS21083C8	Purchased	No	70033	250	Each	85.0000	2	2	
MS21083C8	r di citasca						**		
NUT									
			Location	Lo	c Qty	Loc Code			
			FP002		1				_
			115884		1				-
			ST303		14				-
			115884		0				-
			118077 119309		2				-
			119436		9				-
			119638		2				-
			ST304		70				_
			120142		20				-
/			1 <u>20731</u> 121011		25 25			/^	-
AN8C21A	Purchased	No	121011	250	25 Each	51.0000	2		
	Fulchased	110		230	Each	31.0000		2	=12)
							**	1971	0731
DODI			Location	Lo	c Qty	Loc Code			80 12-04-09
			ST343		51				•
			118758		5				-
			120094		42			27	• •
			120872		4				-

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Work Order ID: 81397

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Parent Item:

D350-636-015

D350-636-015

Parent Item Name: Skidtube STD w/ Training Wearplates, LH

Start Date: 13/03/2012 Start Qty: 1.00

Required Date: 27/03/2012

Required Qty: 1.00

Manufactured

No

250

37.0000

Each

**

<u>Location</u>	Loc Oty	Loc Code
ST	-10	
ST466	47	
71856	1	
76984	36	

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	QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
*	L <u>X</u>				D4168-041	350 SKIDTUBE ASSEMBLY, LH
		X			D4168-042	350 SKIDTUBE ASSEMBLY, RH
			Х		D4168-043	350 SKIDTUBE ASSEMBLY, LH
				Х	D4168-044	350 SKIDTUBE ASSEMBLY, RH
D	1	1	1	1	D2739	WEB
_	8	8	8	8	D2743	SPACER
	1	1	1	1	D2744	CAP
	8	8	8	8	D2745	BUSHING
1	1		1		D3488-041	BLADE FITTING, LH
		1		1	D3488-042	BLADE FITTING, RH
	4	4	4	4	D3490-1	SPACER
	4	4			D3490-3	SPACER
			4	4.	D3490-5	SPACER
	8	8	8	8	D3492-041	PLUG ASSEMBLY
	8	8			D3492-043	PLUG ASSEMBLY
			8	8	D3492-045	PLUG ASSEMBLY
	8	8	8	-8	D3631-1	WASHER
	7	7	7	7	D3873-1	BUSHING
	1	1	1	1	D4154-041	WEARPLATE ASSEMBLY
	1				D4168-1	SKIDTUBE WELDMENT, LH
С		1			D4168-2	SKIDTUBE WELDMENT, RH
			1		D4168-3	SKIDTUBE WELDMENT, LH
i				1	D4168-4	SKIDTUBE WELDMENT, RH
	4	4	_ 4	4	D4170-1	SPACER
i	1	1	1	1	D4171-1	BUSHING
ı						
	4	4	4	4	ALS4-1032-225	INSERT
	4	4	4	4	AN3C6A	BOLT
٦	1	1	_ 1	1	AN3C34A	BOLT
7	4	4	4	4	AN3C36A	BOLT
ĺ	4	4	4	4	AN6C44A	BOLT
	11	1	1	1	AN8C35A	BOLT
ı	9	9	9	9	AN960C10	WASHER (OR NAS1149CO363R)
l	- 4	4	4	4	AN960C10L	WASHER (OR NAS1149CO332R)
ı	11	1	11	1	AN960C816L	WASHER (OR NAS1149CO832R)
. 1	5	5	5		MS21043-3	NUT
3]	4	4	4		MS21043-6	NUT
I	1	1	_ 1		MS21083C8	NUT
[4	4	4	4	NAS1515H3L	WASHER

SHOP COPY **RETURN TO ENGINEERING UNCONTROLLED COPY** SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER D. 81397 MLJ

12/03/14

GENERAL NOTES:

MATERIAL: MAKE D4168-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).

INTERIOR IN MARE DISTOS-17-27-31 FROM DEBOU-S EXTROSION (INTITAL LENGTH = 120.0).

FINISH:

CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3

BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).

TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

UNITS: INCHES UNLESS OTHERWISE NOTED

BREAK SHARP EDGES: NIA
IDENTIFICATION: N/A

WEIGHT: D4168-041/-042/-043/-044 = 32.3 LBS

WELD PER DART QSI 004

FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI

MINIMUM YIELD TENSILE STRENGTH = 36 KSI

COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.

SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL

SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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MFG. A	PPR.	M.	D4168	04168 SHEET 1 OF					
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DE APP	PR.	4-	☐ 350 SKIDTUBE ASSEME	BLY	NTS				
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D4168-041 350 SKIDTUBE ASSEMBLY, LH

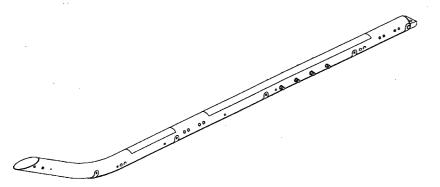
D4168-042 350 SKIDTUBE ASSEMBLY, RH

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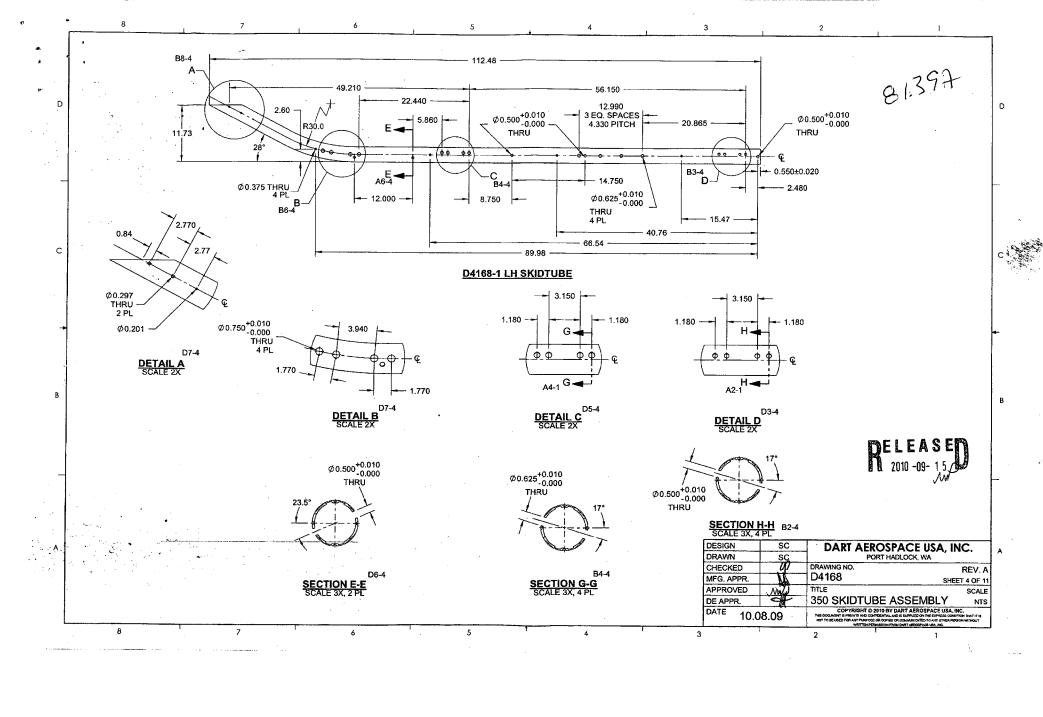
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D4168-044 350 SKIDTUBE ASSEMBLY, RH

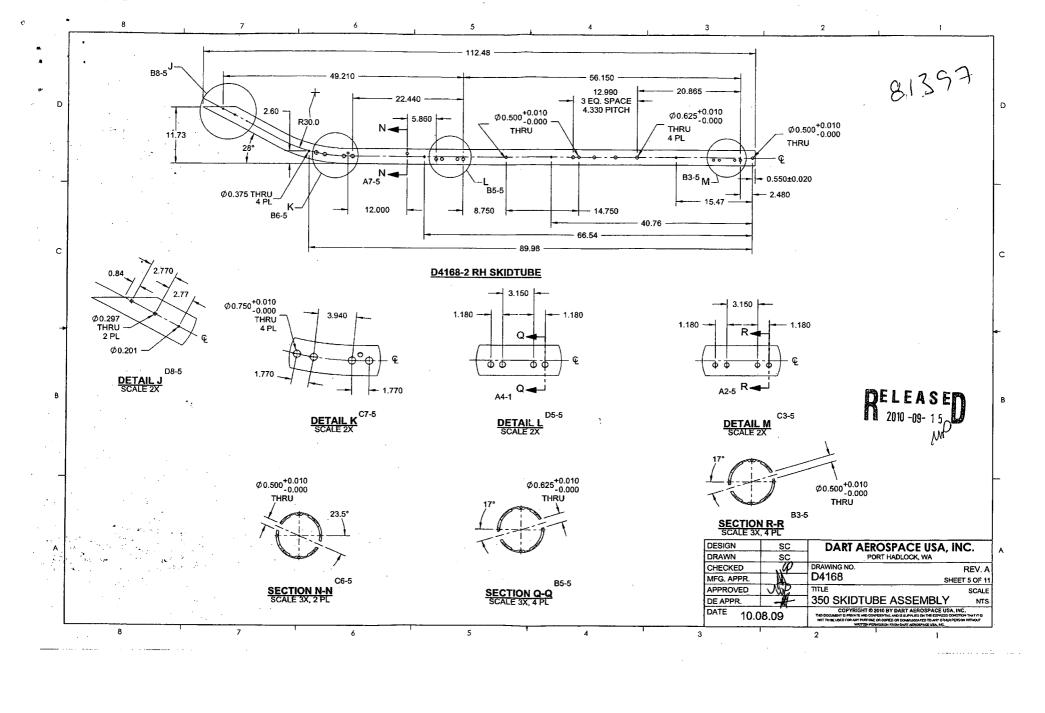


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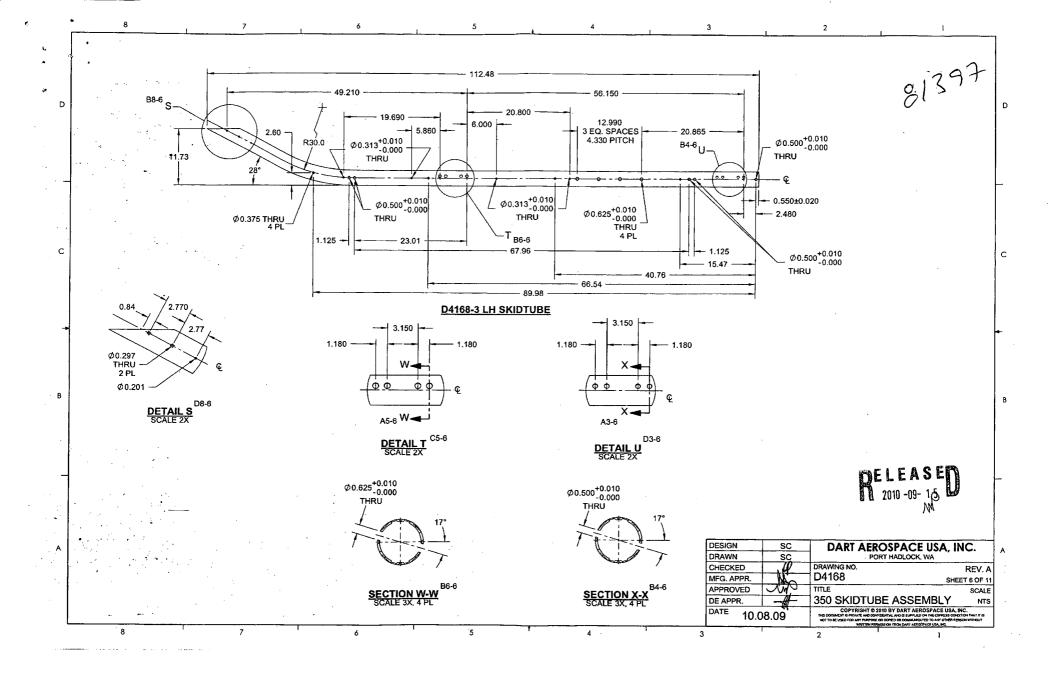
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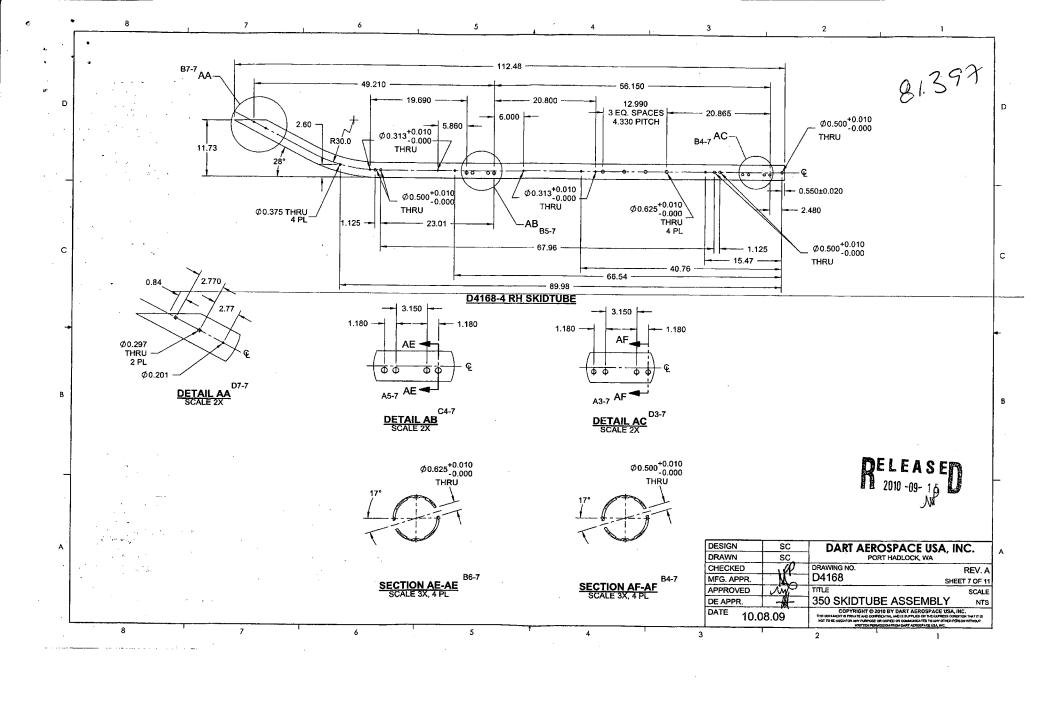
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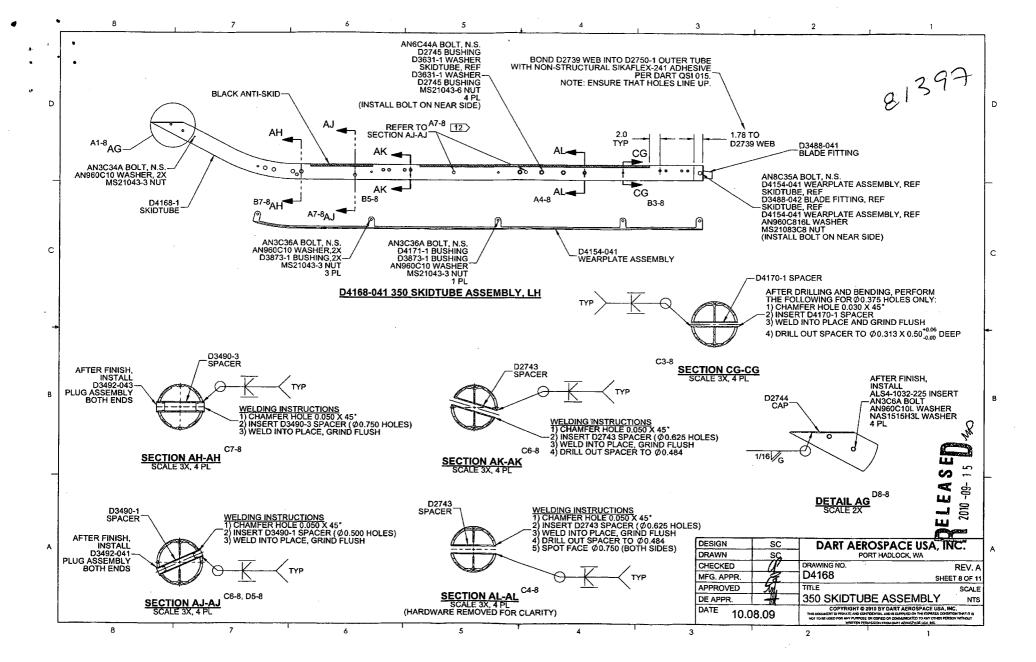
										
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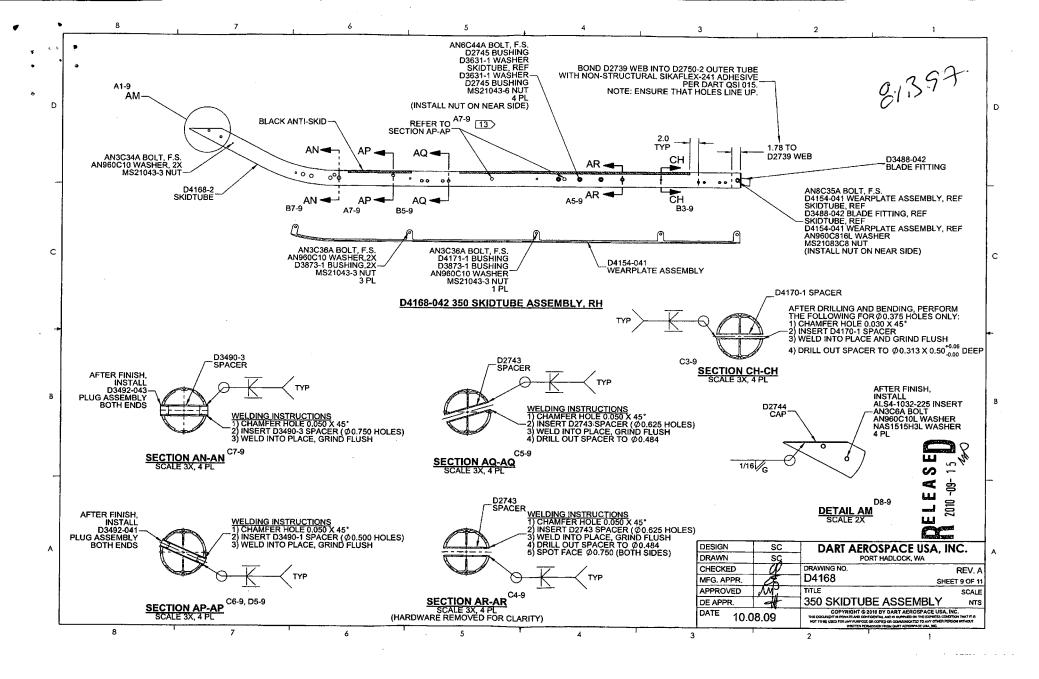
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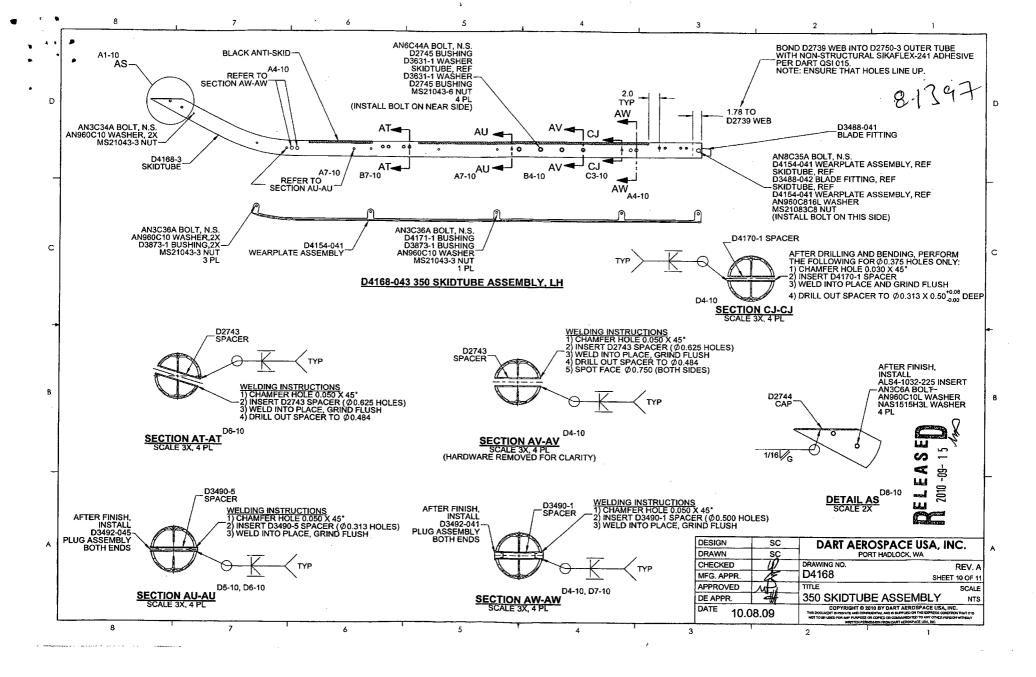
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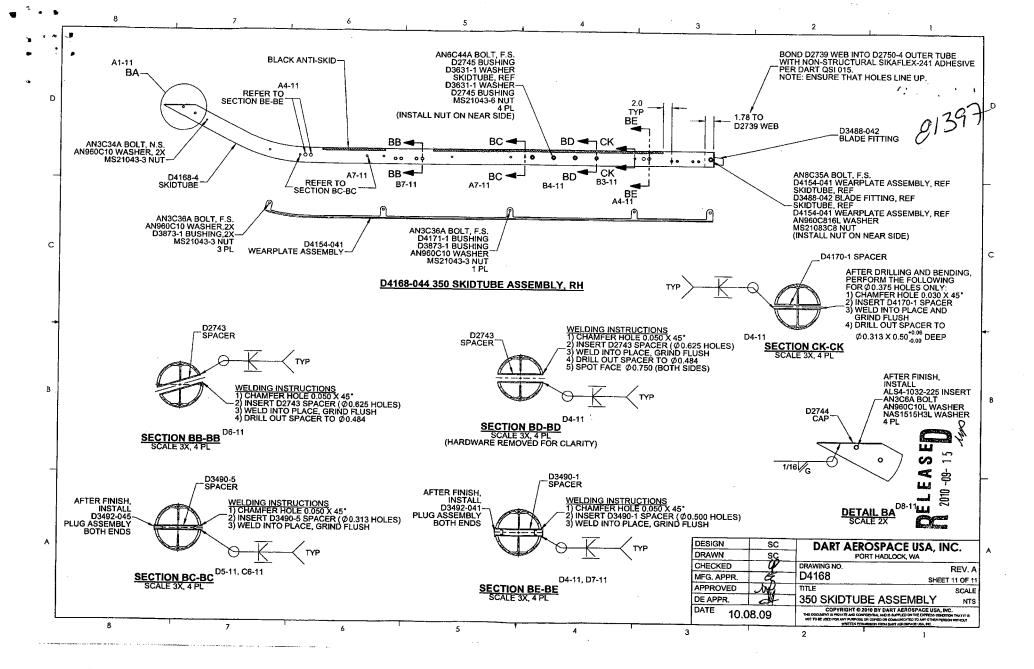
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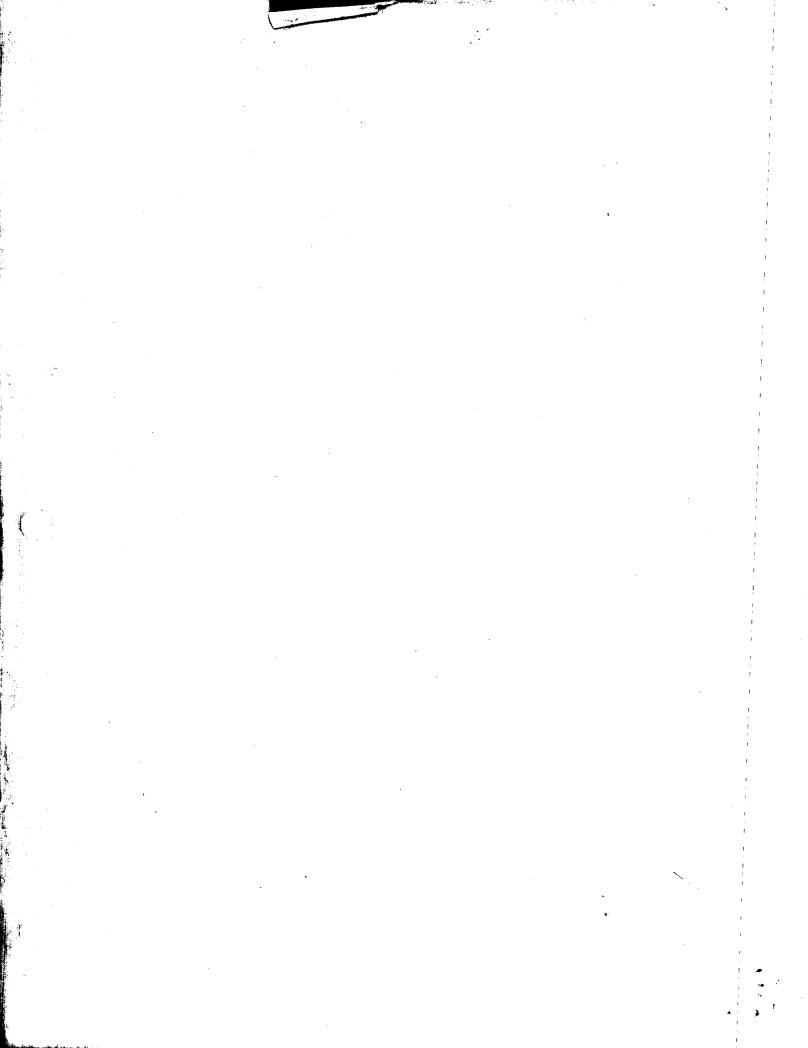
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NO. <u>282</u>

AWS D17.1.2001 QUALIFICATION TEST RECORD

\cap I	11 11						
Name: Korclay L	lliott						
Job number:	84/3						
Part number: \$350-63	36-0//						
Description: Skid tube							
Welding Process: Tig[4] Mig[]							
Base materiel: Alum	allen						
Current: AC[]							
TEST	REQUIREMENTS AND RESULTS						
ILOI I	REQUIREMENTS AND RESCETS						
	,						
Visual:	pass[fail[]						
Penetration:	pass[fail[]						
UNACCEPTABLE							
	,						
Cracks:	pass[/] fail[]						
Undercut:	pass[fail[]						
Pin holes:	pass[] fail[]						
Overlap (cold lap)	pass[fail[]						
Porosity (surface):	pass[4] fail[]						
Coloration:	pass[] fail[]						
Coloration.	pass[0] rant j						
1 . 1 0							
Qualifier Mich Auck	Date of Test Coupon 12.02.01						
Qualities for the same of the	Date of Test Coupon 10,00.01						
Welder Borclay Elist	Date of Test Coupon /2.03.0/						
The court of the court	Date of Test Coupon 10. voj. 01						
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The above named individual is qualified in accordance with AWS D17.1.2001 to weld



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81397 Work Order ID 81397 March-14-12 7:47:18 AM *N900040100** Setup Start Accept D3:0-636-015 Item ID: **Revision ID:** Skidtube STD w/ Training Wearplates, LH Item Name: Cust Item 1D: *1* Start Qty: 1.00 13/03/2012 Start Date: Customer: *1* Req'd Qty: 1.00 **Required Date:** 27/03/2012 Run Reference: Date: Process Plan: MLJ Approvals: Date: SPC (Y/N): Date: QC: Reject Insp. Reject Accept Plan Tool ID Tool# Stamp Number Set Up/ Qty Qty Code Operation Sequence ID/ **Run Hours** Description Work Center ID **Revision Nbr** Draw Nbr C D3492 A D4168 IIN-D350-636 PO14016129 0.00 100 DOCUMENT CONTROL

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Photocopy blue file and type labels per PPP D350-636-015 CHG 002

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